

**Work Order ID 80855**

Thursday, March 01, 2012 3:53:05 PM

*LH*  
**\*80855\***

Page 1

Item ID: D206-642-151

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 3/1/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/9/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*Date: *2-03-1*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

0.00

**\*100\***

DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile &amp; type labels per PPP D206-642-151

CHG001

*N/A*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80855****\*80855\***

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**\*N900040100\***Setup Start **\*NS1\***

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Start Date: 3/1/2012 Start Qty: 1.00

**\*1\***

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Required Date: 3/9/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

**\*110\***

Skidtubes

0.00

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 &amp; DT8169D &amp; DT9771.

9-Locate DT8732 from inner Aft saddle hole &amp; 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 &amp; D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 &amp; doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

1 x CF 12-3-2

SAP 12-03-02

SAP 12-03-22

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Run Start **\*NR1\***

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Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.  
\*\*\*\*no wearplate holes for this skidtube\*\*\*\*

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

SAD 12-03-22

DP 12-3-22

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160	Skidtubes	0.00							
<b>*160*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 3/9/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC6- Inspect dimensions to drawing

0.00

**\*170\***

QC

Memo

0.00

Quality Control

*Handwritten: 12-3-23*

180

Skid tubes

0.00

**\*180\***

Skid tubes

Memo

0.00

Skid tubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 12-03-23 Time: 11400

Finish Date: 12-03-26 Time: 1:00

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 M120813

Sikaflex expire date: 2012-08-13

*Handwritten: SAD (1)*

*Handwritten: 12-03-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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1 0 BE 12/03/26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D206-642-151 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube  
 Start Date: 3/1/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 3/9/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Skidtubes	0.00							
<b>*200*</b>	Skidtubes	0.00							
Skidtubes	<p><b>Memo</b></p> <p>1-remove alodine from around hole and prepare for welding</p> <p>2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.</p> <p>Pick: QtyPart NumberDescriptionBatch A/RAluminum Rod <u>m120/64</u></p> <p>3-Grind welds flush as per Dwg D3804. <i>BB 12/03/26</i></p> <p>4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. <i>BB 12/03/27</i></p> <p>5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr <i>DP/CC</i></p>								

12-3-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 80855**

Thursday, March 01, 2012 3:53:05 PM

**\*80855\***

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Item ID: D206-642-151

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 3/1/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/9/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
<b>*210*</b>	HandFinish	0.00				1			<i>SB 12/03/27</i>
Hand Finishing	Memo Install D2680-041 Nut Plate as per Dwg D3804								
215	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*215*</b>	QC	0.00				1x			<i>CP 12.03.28</i>
Quality Control	Memo								
220	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*220*</b>	QC	0.00							<i>SB 12/03/28</i>
Quality Control	Memo								

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 80855****\*80855\***

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Revision ID: Stop **\*NS2\***  
Item Name: Replacement Skidtube  
Start Date: 3/1/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 3/9/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

QC5- Inspect part completeness to step on W/O

0.00

**\*230\***

QC

Memo

0.00

Quality Control

240

Pressure Wash per QSI005 4.3

0.00

**\*240\***

HandFinish

Memo

0.00

Hand Finishing

*IXP M-12/03/29*

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*250\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:*8h25*  
*320°F*  
*8h55**m120222**1 0 2P 12/04/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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260

QC3- Inspect Part Finish

0.00

**\*260\***

QC

Memo

0.00

Quality Control

1 htl d All 12/04/04

270

HandFinishing

0.00

**\*270\***

HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

1 htl d All 12/04/04

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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280

0.00

**\*280\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/RSikaflex-291 1110318Sikaflex expire date: 12/08

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: 111209091644 4 90 11/04/05

290

0.00

**\*290\***

QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

1X 4 11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300 <b>*300*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
			8 reballos						
310 <b>*310*</b> Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D206-642-151 Location: _____ PPP Rev: <u>PPP 80971</u>	0.00 0.00							
			4444 @						
320 <b>*320*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							
			12/4/12 J						

112-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, March 01, 2012 3:53:09 PM

Page 1

Work Order ID: 80855

\*80855\*

Parent Item: D206-642-151

\*D206-642-151\*

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC  
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured No

110

Each

30.0000

1

1

\*D2620\*

Skidtube, 206 Skidtube

\*\*

CF 12-32

Location

Loc Qty

Loc Code

LG

30

77996

1

77999

10

78000

5

79542

1

79543

2

79544

8

79545

3

D2647

Manufactured No

110

Each

63.0000

1

1

\*D2647\*

Cap

\*\*

8/22/03/02

Location

Loc Qty

Loc Code

LG002

63

75482

63

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Thursday, March 01, 2012 3:53:09 PM

Work Order ID: 80855

**\*80855\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

7,334.000

52

52

**\*CR3212-4-04\***

Cherry Rivet

\*\*

SAD 12-03-23

LocationLoc QtyLoc Code

ST331

168

116471

78

117816

3

118686

1

118840

16

119017

60

119075

10

st510

7166

119075

7166

D2654-1

Manufactured

No

180

Each

17.0000

1

1

**\*D2654-1\***

Web

\*\*

SAD 12-03-23

LocationLoc QtyLoc Code

LG

17

79540

5

79541

10

80054

2

D3286-1

Manufactured

No

180

Each

121.0000

2

**\*D3286-1\***

Doubler

\*\*

SAD 12-03-22

LocationLoc QtyLoc Code

LG002

217

74872

6

78014

93

ST046

-96

76772

22

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 3

Thursday, March 01, 2012 3:53:09 PM

Work Order ID: 80855

**\*80855\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

D2649      Manufactured      No      200      Each      1,831.000      19      19

**\*D2649\***

Cross Bolt Spacer

\*\*

BE 12/03/26

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	1374	
77574	2	
79502	403	19
79503	399	
79504	309	
79565	261	
LG001	457	
65317	1	
68224	2	
68507	11	
71355	2	
72704	2	
72841	11	
73390	8	
73857	21	
73858	53	
73859	4	
73860	4	
78020	6	
78583	2	
79566	330	

D3286-3      Manufactured      No      200      Each      125.0000      2      2

**\*D3286-3\***

Spacer

\*\*

BE 12/03/27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	15	
78015	15	
LG001	110	
74117	1	
79557	109	2

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, March 01, 2012 3:53:09 PM

Work Order ID: 80855

\*80855\*

Parent Item: D206-642-151

\*D206-642-151\*

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

210 Each

171.0000

1

1

\*D2680-041\*

Nut Plate

\*\*

1 12/03/27

Location

Loc Qty

Loc Code

ST013

116

78016

116

ST019

55

76790

55

CR3212-4-03 Purchased No

210 Each

1,512.000

2

2

\*CR3212-4-03\*

Cherry Rivet

\*\*

2 12/03/27

Location

Loc Qty

Loc Code

FP002

522

114859

522

ST331

990

110139

2

119017

988

AN960JD416 NAS1149D0463J Purchased No

210 Each

24.0000

1

1

\*AN960JD416\*

Washer

\*\*

1121255 (x1) 12/04/08

Location

Loc Qty

Loc Code

ST351

24

116289

24

CCR264SS3-3 Purchased No

210 Each

767.0000

2

2

\*CCR264SS3-3\*

Cherry Rivet

\*\*

2 12/03/27

Location

Loc Qty

Loc Code

ST331

767

113973

2

117849

129

119017

636

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 5

Thursday, March 01, 2012 3:53:09 PM

Work Order ID: 80855

\*80855\*

Parent Item: D206-642-151

\*D206-642-151\*

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

212.0000

1

1

\*MS27039-4-06\*

Screw

\*\*

XL 12/04/05

Location

Loc Qty

Loc Code

ST292

212

119075

212

XL

D2651-1

Manufactured

No

270

Each

749.0000

6

6

\*D2651-1\*

Plug

\*\*

M/L 12/04/05

Location

Loc Qty

Loc Code

FP001

884

57869

1

66445

10

69018

2

70827

2

70839

8

71037

8

77559

30

78584

245

79234

278

FP-A

-135

77559

1

78124

164

81804

6

D2651-3

Manufactured

No

270

Each

2,065.000

6

6

\*D2651-3\*

O-Ring

\*\*

M/L 12/04/05

Location

Loc Qty

Loc Code

FP001

137

61962

12

73828

125

FP-A

1928

78126 ✓

1928

6

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 6

Thursday, March 01, 2012 3:53:09 PM

Work Order ID: 80855

**\*80855\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280

Each

129.0000

14

14

**\*D3873-1\***

Bushing

**\*\***

B76791 (x1) 11/16/06

LocationLoc QtyLoc Code

ST067

129

64760

1

68247

4

73829

19

73830

2

79560

103

D2646

Manufactured No

280

Each

60.0000

1

1

**\*D2646\***

Aft Cap

**\*\***

B79500 (x1) 11/16/06

LocationLoc QtyLoc Code

FP002

60

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

44

D3805-041

Manufactured No

280

Each

6.0000

1

1

**\*D3805-041\***

Wearplate Assembly Fwd, Low Gear

**\*\***

B78007 (x1) 11/16/06

LocationLoc QtyLoc Code

FP001

1

76779

1

FP002

5

78002

5

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 7

Thursday, March 01, 2012 3:53:09 PM

Work Order ID: 80855

**\*80855\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,259.000

2

2

**\*MS27039-1-08\***

Screw

\*\*

11121011 (x2) 111210410-6

Location

Loc Qty

Loc Code

ST291

1259

117423

81

119075

172

119109

6

120308

1000

MS21042L3

Purchased

No

280

Each

3,758.000

7

7

**\*MS21042L3\***

Nut

\*\*

11121011 (x2) 111210410-6

Location

Loc Qty

Loc Code

ST300

3758

117441

16

117885

32

118451

5

118927

3

119017

3505

119075

197

D3805-045

Manufactured

No

280

Each

12.0000

1

1

**\*D3805-045\***

Wearplate Assembly Aft, Low Gear

\*\*

1378013 (x1) 111210410-6

Location

Loc Qty

Loc Code

FP001

12

73817

1

74896

1

78010

10

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

**\*AN960JD10L\***

Washer

\*\*

11120644 (x2) 111210410-6

Thursday, March 01, 2012 3:53:09 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Picklist Print**

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Thursday, March 01, 2012 3:53:09 PM

Work Order ID: 80855

**\*80855\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No

280 Each

846.0000 7 7

**\*AN3-37A\***

\*\*

Bolt

LocationLoc QtyLoc Code

ST353

846

117619

4

119086

842

NAS1149D0363J Purchased No

280 Each

2,337.000 7 7

**\*NAS1149D0363.J\***

\*\*

Washer

LocationLoc QtyLoc Code

ST298

2337

117601

61

118077

1

118612

18

119537

309

120142

330

120308

618

120644

1000

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

#### NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

80855 MCT  
12/03/02

RELEASED  
UP 09-03-03  
per ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.07		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3804  
REV. A  
SHEET 1 OF 5  
SCALE NTS

SKIDTUBE ASSEMBLY, 206A/B

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

20875



DESIGN	99	<b>DART AEROSPACE USA, INC</b>	
DRAWN	J	<b>PORT HADLOCK, WA</b>	
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	BE	D3804	SHEET 2 OF 5
APPROVED	J	TITLE	SCALE
DE APPR.	J	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATELY OWNED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION FROM DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR ANY PURPOSE OR CONSTRUCTION OR COMMUNICATION TO ANY OTHER PERSON WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

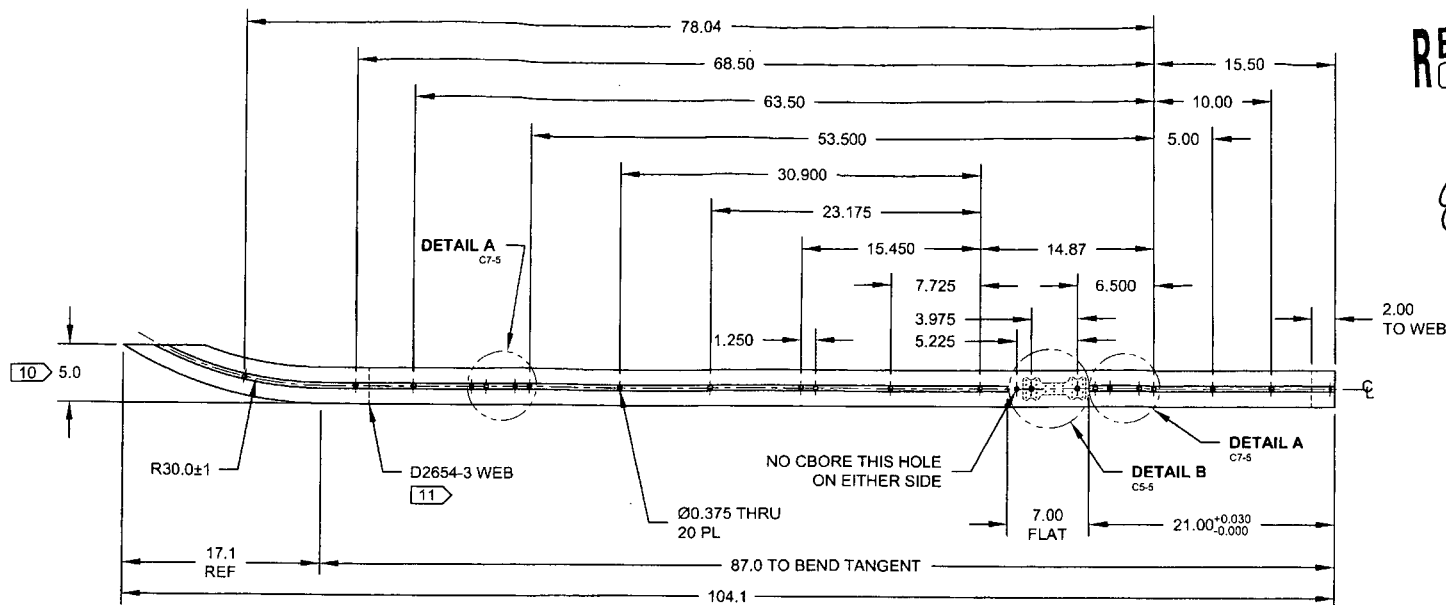
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

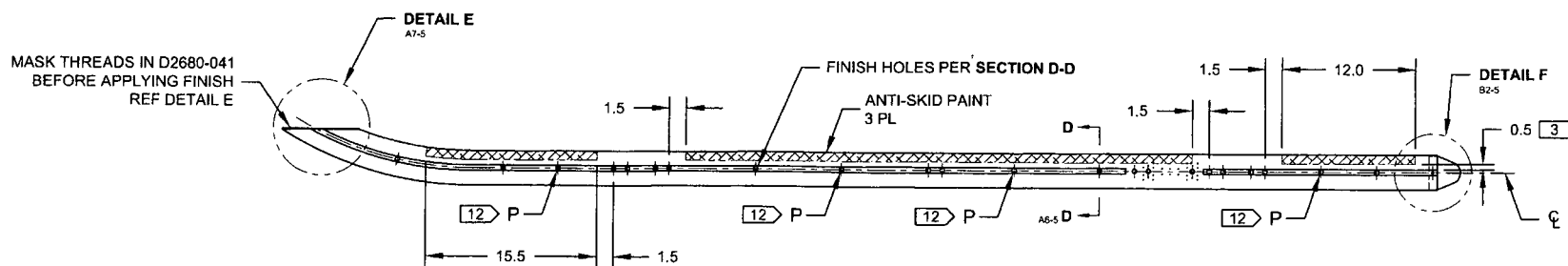
**NOTE:** Date & initial all entries

RELEASED  
09.13.03

80855



**D3804-043 BENDING/DRILLING DETAIL**



**D3804-043 ASSEMBLY/FINISHING DETAIL**

DESIGN	91	<b>DART AEROSPACE USA, INC</b>
DRAWN	1	PORT HADLOCK, WA
CHECKED	2	DRAWING NO. REV. A
MFG. APPR.	3	D3804 SHEET 3 OF 5
APPROVED	4	TITLE SCALE
DE APPR.	5	SKIDTUBE ASSEMBLY, 206A/B NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

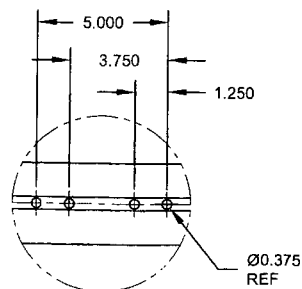
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

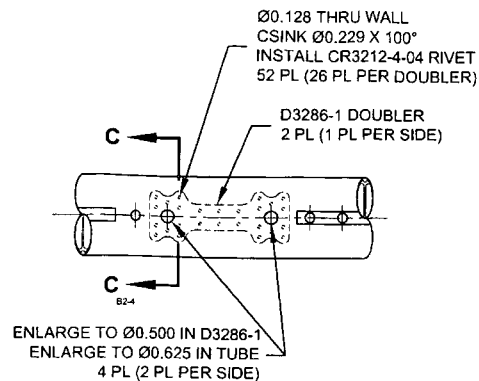
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

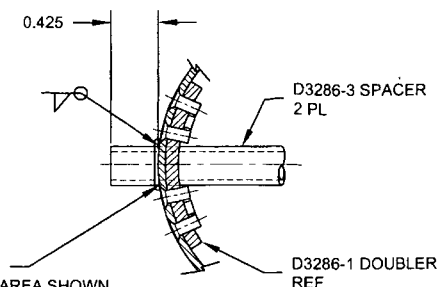
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UP 09.03.03



**DETAIL A** D6-2  
C2-2  
D6-3  
C2-3  
SCALE NONE



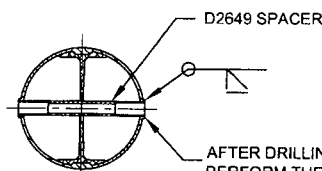
**DETAIL B** C3-2  
C3-3  
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE AND GRIND FLUSH

*0005*

**SECTION C-C** C6-4  
PARTIAL SECTION  
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

**SECTION D-D** A4-2  
A4-3  
FOR Ø0.375 HOLES ONLY  
SCALE NONE

DESIGN	97	<b>DART AEROSPACE USA, INC</b>	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 4 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

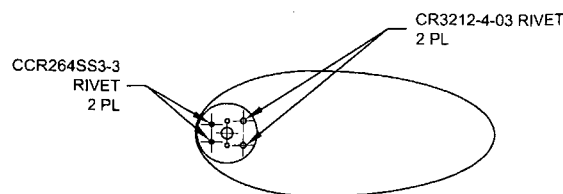
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



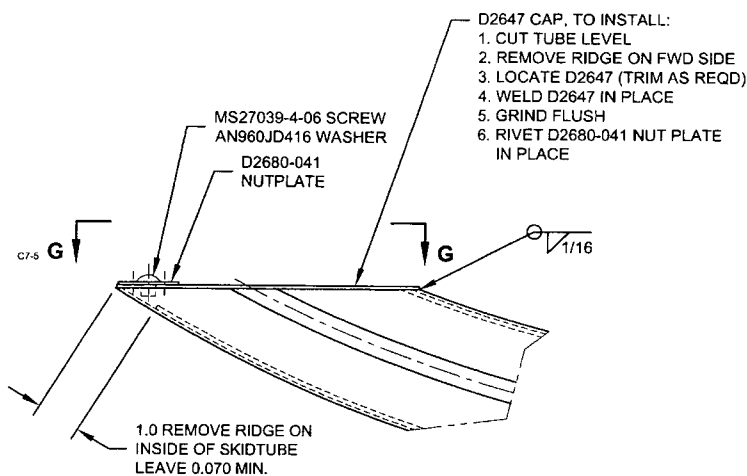
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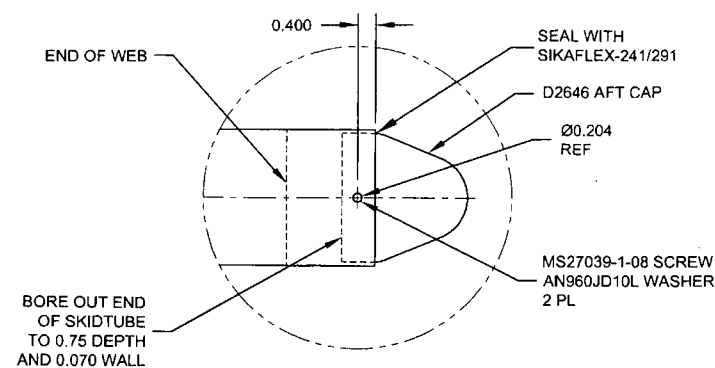
**VIEW G-G**  
SCALE NONE

A7-5



**DETAIL E**  
SCALE NONE

B7-2  
B7-3



**DETAIL F**  
SCALE NONE

B2-2  
B2-3

DESIGN	97	<b>DART AEROSPACE USA, INC</b>	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	07	DRAWING NO. D3804	REV. A
MFG. APPR.	BE	SHEET 5 OF 5	
APPROVED	70	TITLE	SCALE
DE APPR.	TH	SKIDTUBE ASSEMBLY, 206A/B	NTS
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NOTE: Date & initial all entries

NO. 252

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 66358  
Part number: 5206 642 541  
Description: 206  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Pat Curry Date of Test Coupon 11-05-09

Welder Barclay Elliott Date of Test Coupon 11-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld